

5/43

SPLIT

DART AEROSPACE LTD	Work Order:	24519 A
Description: Wearplate	Part Number:	D3460-1
Dwg: D3460 Rev. A; D2577 Rev. E	Qty:	8 4
		Page 1 of 1.

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	HA	05.10.20	8
2	PG	Issue P/O: 2008744 Email or Ship DXF file to vendor Laser Cut D2577-101 flat pattern as per Dwg D2577 Material release note required	LA	05/09/20	8
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	LA	05/10/12	8
4	QC6	Inspect dimensions per template D2577-101T	SB	05/10/20	8
5	GB	Deburr if necessary		N/A	
6	GB	Form on brake as per Dwg D2577 using DT8155 and DT8179	SB	05/10/20	8
7	GB	Form end joggle as per Dwg D2577 using DT8157 Identify as D3460-1	SB	05/10/20	8
8	GB	Form Detail "A" joggle of Dwg D3460 using DT8157	SB	05/10/20	8
9	QC5	Inspect work to Step 8	J	05.10.25	8
10	WS	Weld hard surface using DT8308A & DT8308B as per Dwg D3460 Qty Part Number Description Batch A/R 7560 Hardcoat Rod M17953	CRK	05.11.15	4
11	QC9	Inspect weld	HA	05/11/15	4
12	FP	Powder Coat Grey Sandtex (Ref.4.3.5.6) per QSI 005 4.3	ML	05.11.15	4
13	QC3	Inspect Powder Coat	CL	05/11/16	4
14	ST	Identify and Stock	ML	05.11.16	4
15	AC	Cost / part: 13.97	SAC	05.11.21	4
16	DC	Close W/O 13.97 Inspect Level 21	CD	05.11.21	4

Rev	Date	Change	Revised By	Approved
A	05.10.20	New Issue	KJ/EC	HA

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

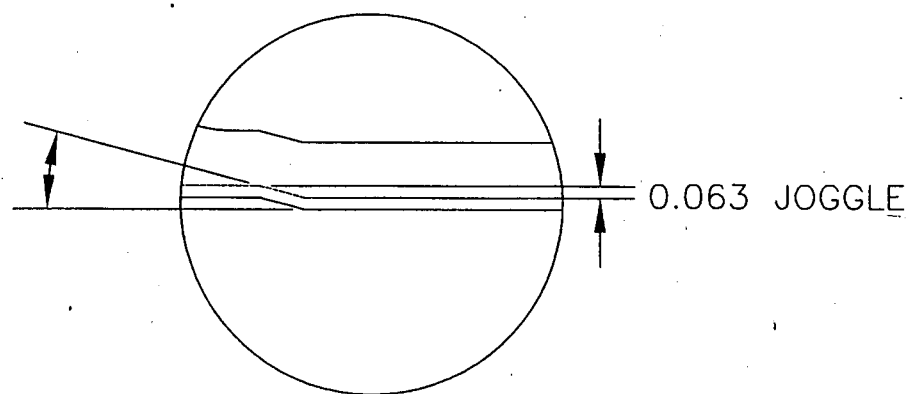
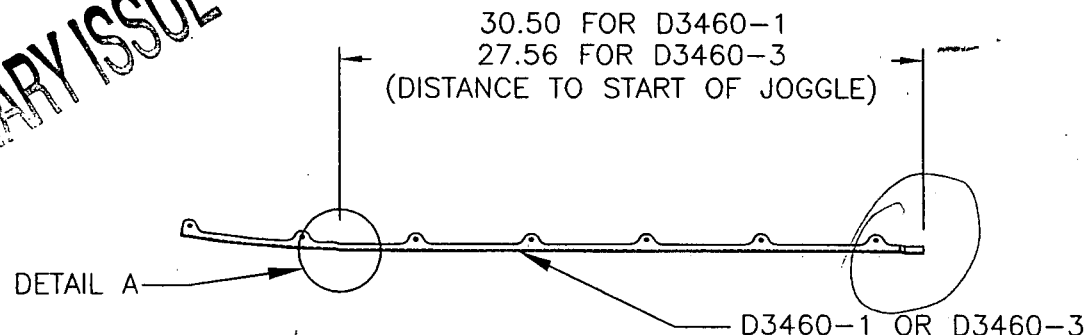
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ID Date: 05/11/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

PRELIMINARY ISSUE



D3460-1/-3 WEARSHOE

- 1) MAKE D3460-1 FROM D2577-11 LONGITUDINAL BEND
- 2) MAKE D3460-3 FROM D2577-13 LONGITUDINAL BEND
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5. COPY
RETURN TO
ENGINEERING
T1
ADMENT
OFFICE
WORK ORDER
NO. 24519

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.10.04			DRAWING NO. D3460
				TITLE WEARSHOE
				SHEET 1 OF 1
				SCALE 1:10
A		05.10.04		NEW ISSUE

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
11:50 am

Work Order No : 0024519
Project Name : D3460-1
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D3460-1
Description :
Manufactured : No
Amount Req'd : 0
Amount Done : 0
Start Date : 10-11-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Wednesday, 11/16/2005 1:22:21 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 24519	
Estimate Number : 10620	
P.O. Number :	Part Number : D34601
This Issue : 11/16/2005 S.O. No. :	Drawing Number : D3460 REV. A
Prsht Rev. : NC	Project Number :
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 11/30/2005 Qty: 8 Um: Each
Checked & Approved By :	
Comment : Est: A 05.10.20 New Issue KJ/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut D2577-101 flat pattern as per Dwg D2577

Material release note required

2.0	D2577101F	Wearplate (flat pattern)
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per inspection template D2577-101T

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

6.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1- Form on brake using DT8155 and DT8179 as per Dwg D2577 Rev: _____

2- Form end joggle using DT8157 as per Dwg D2577

3- Form Detail "A" joggle using DT8157 as per Dwg D3460 Rev: _____

Date: Wednesday, 11/16/2005 1:22:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 24519

Part Number: D34601

Job Number:



Seq. #:

Machine Or Operation:

Description :

Identify as D3460-1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D3460 Rev: ____

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ____

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



NO DWA TO
ATTACH TO
ESTIMATE

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:22 pm

Work Order No : 0024519
Project Name : D3460-1
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D3460-1
Description : Wearplate
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 10-18-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	1.13	100.00		
Production Cost	0.00	27.24	100.00	0.00	27.24
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	27.24	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	27.24			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	(-27.24)

M/S J/B
11.16